

Work Order ID 83472

83472

Page 1

April-18-12 2:40:06 PM

Item ID: D4149-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Lug Plate, Aft

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/18 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4149

C

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4149

Prog Rev: C

Dwg Rev: C

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 0 Jm/ML 12-4-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

N900040100

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12

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

5-26-13

(12)

Quality Control

150

Identify as per dwg & Stock Location: 8-133

0.00

150

Packaging

Memo

0.00

Packaging

(124)

12-4-30

88

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/5/11

MF
12-05-01

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NOTE: Date & initial all entries

Picklist Print

April-18-12 2:40:10 PM

Page 1

Work Order ID: 83472

83472

Parent Item: D4149-1

D4149-1

Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	72.0900	0.1355	1.711579			

M304S11GA

304/316 0.125 Sheet

**

Location

Loc Qty

Loc Code

MAT020

72.09

121070

5.59

121380

66.5

21380
1.8

Jmy
12-4-29

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DART AEROSPACE LTD		Work Order:	83472
Description: Aft Crosstube Lug Plate		Part Number:	D4149-1
Inspection Dwg: D4149	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.129	✓		vern	HB-02
Ø0.191	+0.005/-0.001	0.191	✓		vern	HB-02
Ø0.257	+0.006/-0.001	0.257	✓		vern	HB-02
Ø0.38	+0.006/-0.001	0.379	✓		vern	HB-02
0.380	+/-0.010	0.389	✓		vern	HB-02
0.469	+/-0.010	0.478	✓		vern	HB-02
0.310	+/-0.010	0.316	✓		vern	HB-02
0.750	+/-0.010	0.756	✓		vern	HB-02
3.25	+/-0.030	3.261	✓		vern	HB-02
0.65	+/-0.030	0.646	✓		vern	HB-02
0.63	+/-0.030	0.636	✓		vern	HB-02
5.46	+/-0.030	5.470	✓		vern	HB-02
3.80	+/-0.030	3.808	✓		vern	HB-02
2.13	+/-0.030	2.137	✓		vern	HB-02
1.313	+/-0.010	1.318	✓		vern	HB-02
0.625	+/-0.010	0.632	✓		vern	HB-02
0.375	+/-0.010	0.383	✓		vern	HB-02
1.175	+/-0.010	1.183	✓		vern	HB-02
0.752	+/-0.010	0.754	✓		vern	HB-02
1.588	+/-0.010	1.592	✓		vern	HB-02
1.587	+/-0.010	1.593	✓		vern	HB-02
11.15	+/-0.030	11.152	✓		vern	HB-02
0.750	+/-0.010	0.758	✓		vern	HB-02
1.55	+/-0.030	1.557	✓		vern	HB-02
1.12	+/-0.030	1.129	✓		vern	HB-02
8.42	+/-0.030	8.421	✓		vern	HB-02
2.70	+/-0.030	2.696	✓		vern	HB-02
0.125	+/-0.010	0.117	✓		vern	HB-02
Ø0.252	+0.003/-0.000	0.252	✓		vern	HB-02

Measured by: JM	Audited by: S	Preliminary Approval:
Date: 12-4-29	Date: 12/04/31	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	

Dart Aerospace Ltd

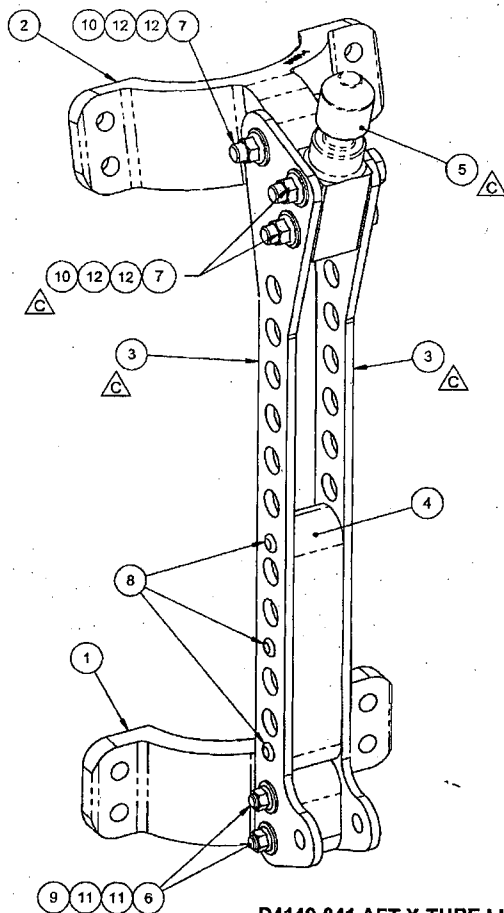
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D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83472 MCT
12/04/18

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

RELEASED
2011-02-24
JMP

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (C3-1, D7-2)	SC	11.02.22
B	MS20815-4M18 WAS MS20815-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20815-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-807-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY OTHER MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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AN4C13A BOLT
NAS1149C0432R WASHER, 2X
MS21043C4 NUT
3PL

D4149-5
EYEBOLT STUD

MS20615-4M18
RIVET
3 PL

D4149-041 AFT X-TUBE LUG ASSY

D4091-1
MOUNTING LUG

D4149-1
AFT X-TUBE LUG PLATE
2 PL

D4149-3
SPACER

AN3C12A BOLT
NAS1149C0332R WASHER, 2X
MS21043C3 NUT
2 PL

D3910-1
X-TUBE LUG

83472

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2011-02-24

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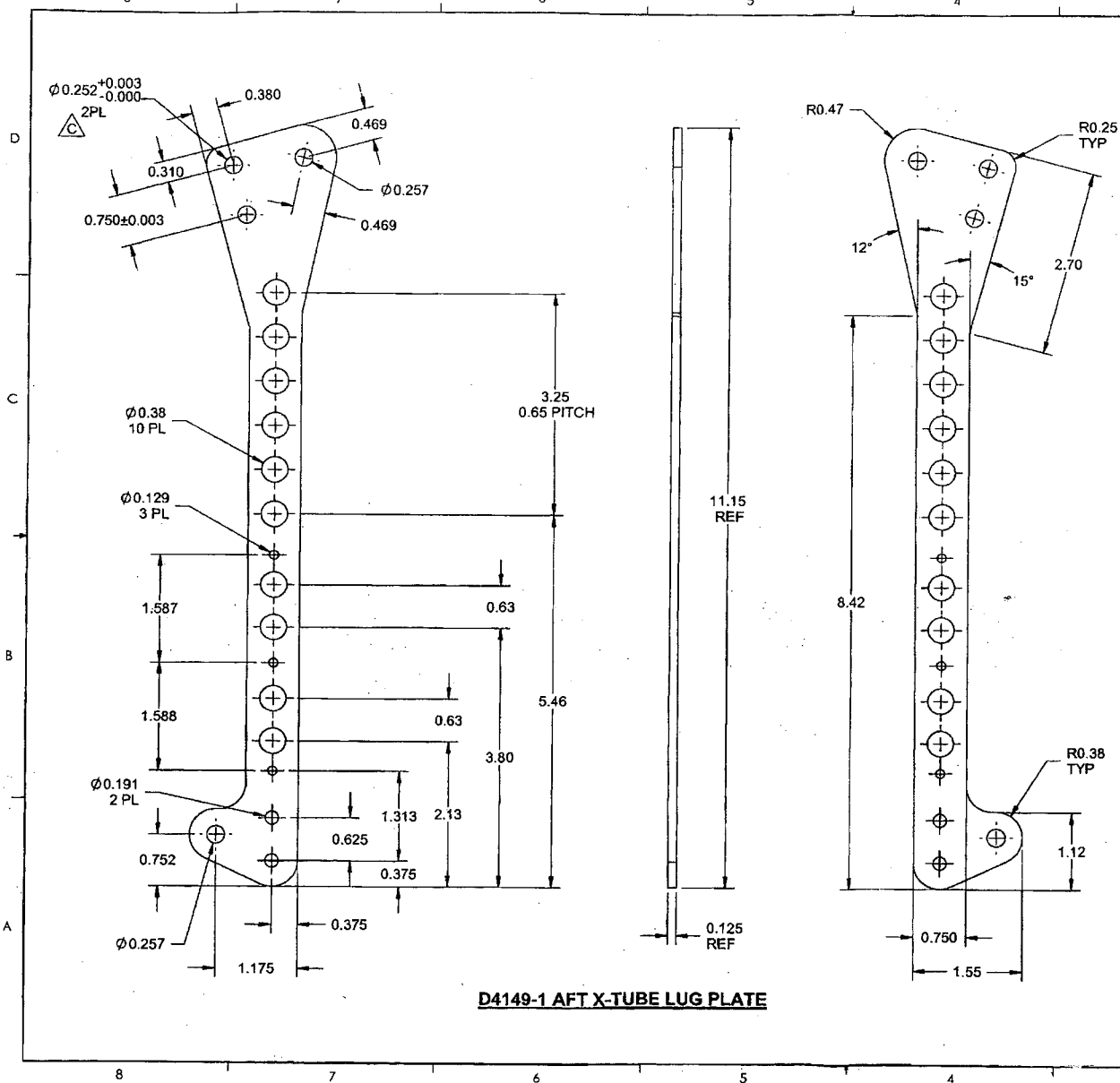
83472

RELEASED
2011-02-20

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

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D4149-1 AFT X-TUBE LUG PLATE



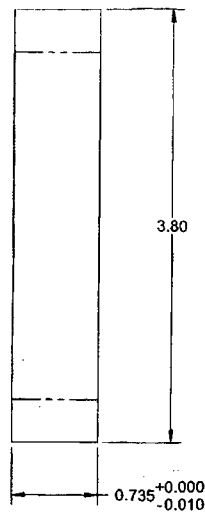
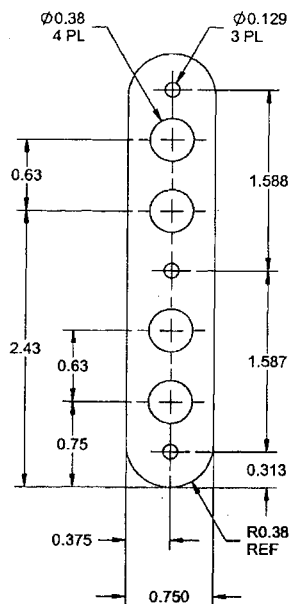
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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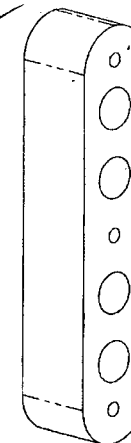
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NOTE: Date & initial all entries



D4149-3 SPACER

83472



NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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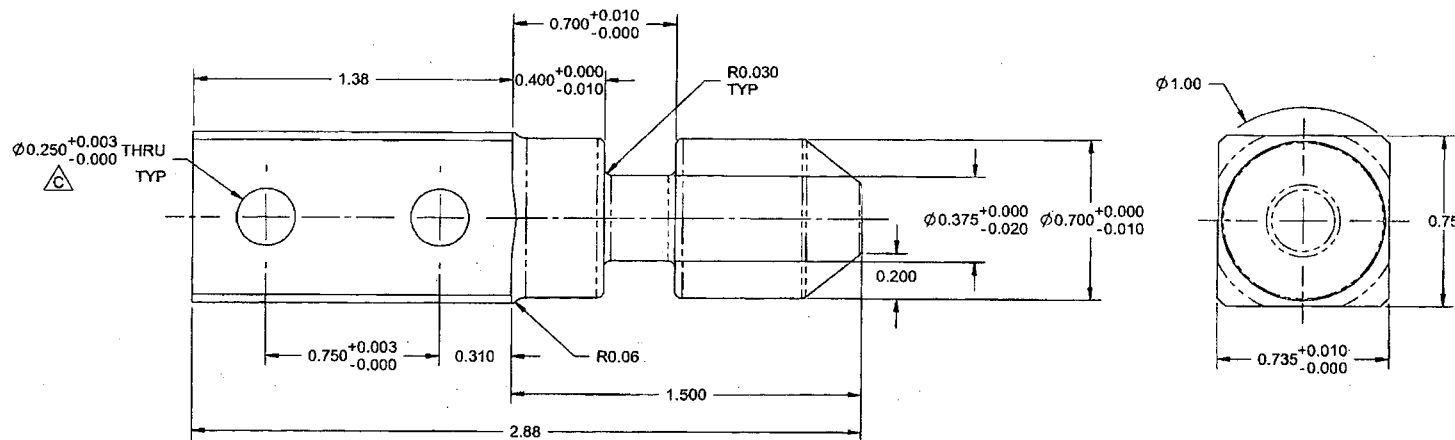
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D4149-5 EYEBOLT STUD

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

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DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
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